

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005161**Date Inspected:** 05-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:****Steel Structure Welding Shop:**

Tower Saddle Steel Structure T1-3: Caltrans Quality Assurance Inspector (QAI) representative observed Japan Steel Works (JSW) welders in process of grinding weld profiles of weld numbers 9Y-11V (3-2) (3-3) and 9Y-12V (3-2) (3-3) for MT test purpose. Based on Caltrans QA Inspector observation, no discrepancies were noted.

W2E3 West Deviation Saddle Steel Structure: Caltrans QAI representative observed a JSW welder perform a SMAW welding on temporary reinforce supports around all the rib plates and stem plate. The temporary reinforce supports are to prevent distortion during the production welding. The proper filler metal used for SMAW welding is Hoballoy 9018-M with 5mm diameter electrode made by Hobart Brothers, USA. The SMAW welding process and parameters have been monitored and recorded by CWI inspector Mr. Chung Kuan.

Casting Shop:

The NDT test schedule on casting portion W2W1, T1-2 and T1-3 has been cancelled for today.

Summary of Conversations:

As noted within the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
